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**Amendments to the Specifications:****Please replace paragraph [0017] with the following paragraph:**

[0017] The particular details of flange 26 are best illustrated in Figures 2, 4, 5 and 6. After the circular blank 12 is stamped or rolled to define a flange 26, as illustrated in Figure 2, with the I I shaped openings to define a first plurality of arcuate projections 40, 40', ...40<sup>n</sup> that are sequentially separated from a second plurality of arcuate projections 42, 42', ...42<sup>n</sup>. A corresponding base 39 for each of the second plurality of radial slots 38, 38', ...38<sup>n</sup> is located adjacent radial plane 11, shown by dashed lines in Figure 4 that extends from the axis of the resulting first shell 10. The first plurality of arcuate projections 40, 40', ...40<sup>n</sup> each have substantially parallel axial sides defined by the axial slots 36, 36', ...36<sup>n</sup> that extend from the radial plane 11 that is aligned with a base 39 of the radial slots 38, 38', ...38<sup>n</sup>. The second plurality of arcuate projections 42, 42', ...42<sup>n</sup> each have a first 44 and a second 46 radial tab thereon with corresponding edges 43 and 45 that are separated from the base 39 a fixed distance "X" defined by the width of the second plurality of radial slots 38, 38', ...38<sup>n</sup>. The first and second radial tabs (44, 46) each have a length defined by the arcuate length of a radial slot (38) less the width of an axial slot (36).

**Please replace paragraph [0018] with the following paragraph:**

[0018] The resulting first shell 10 is coated with an elastomeric material that inhibits the oxidation of the surface of the shell 10. After shell 10 has been coated, it is ready for assembly with a second shell 30 through a crimping process as illustrated in Figure 3. In order to perform the crimping process, bead 27 is located in groove 23 adjacent shoulder 20 and a force is applied to bring shell 30 toward shell 10 such that an edge 206 on peripheral surface 204 of the opened end 202 of shell 30 is brought into alignment with radial plane 11. Thereafter a force is applied to the arcuate surface of the first plurality of arcuate projections 40, 40', ...40<sup>n</sup> by ram 500 300 such arcuate surface 41 engages edge 206 and holds opened end 202

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in a fixed position with respect to shoulder 20 to form a unitary structure with the interior sealed from the surrounding environment, as shown in Figures 4, 5 and 6. The deformation of the first plurality of arcuate projections 40,40',...40" with respect to the cylindrical surface of the flange 26 is between 14-20 degrees and as a result the coating has sufficient elasticity that cracks are not created along the point of engagement 41' on the top or 41 on the bottom 41 of the arcuate projections 40,40',...40" of shell 10 and neither the peripheral surface 204 ~~of shell 30~~ nor is the ~~peripheral surface 204 of the opened end 202 of shell 30~~ is exposed to the surrounding environment as ~~it is~~ they are entirely covered by flange 26.

Please replace paragraph [0021] with the following paragraph:

[0021] A first shell 10 is selected from a supply source. The first shell 10 having been stamped and its entire external surface coated with an oxidization protecting coating. The first shell 10 is characterized by a cylindrical body 14 with a closed end 16 and an opened end 18. A shoulder 20 is located adjacent the opened end 18 to define a flange 26. The flange 26 has a first plurality of axial slots 36,36',...36" that axially extend from the opened end 18 toward the shoulder 20 and engage a second plurality of radial slots 38,38',...38" to create an "\_I I\_" shaped openings adjacent a radial plane 11 with respect to the axis of the shell 10. The "\_I I\_" shaped openings define a first plurality of arcuate projections 40,40',...40" that are separated from a second plurality of arcuate projections 42,42',...42" such that each of the first plurality of arcuate projections 40,40',...40" have substantially parallel axial sides that are perpendicular with a base 39 of the radial slots 38,38',...38" associated with that second plurality of arcuate projections 42,42',...42" and radial plane 11. Each of the second plurality of arcuate projections 42,42',...42" have a first 44 and a second 46 radial tab that are separated from the base 39 by a fixed distance X defined by the width of the second plurality of radial slots 38,38',...38".

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Please replace paragraph [0026] with the following paragraph:

[0026] A second force  $F^2$  provided by a single hydraulic ram [500] 300 is radially applied by a die to bend the first plurality of arcuate projections 40, 40', ...40" toward the axial center of the second shell 30 bring surface 41 thereon into engagement with edge 206 on the second peripheral surface 204 such that chambers 32 and 34 are sealed from the surrounding environment and the first shell 10 is fixed to the second shell 30, as illustrated in Figure 4, 5 and 6. The engagement of surface 41 on the bottom of the first plurality of arcuate projections 40, 40', ...40" with edge 206 on the second peripheral surface 204 is along the entire arcuate length of each arcuate project 40.

Please replace paragraph [0028] with the following paragraph:

[0028] Once ram [500] 300 has completed bending the first plurality of arcuate projections 40, 40', ...40" toward the axis of shell 30 the resulting sealed joint can be achieved by a visual observance of the existence of gap "X". If more definitive evidence is necessary a tool could be inserted in gap X to confirm the relative positions of the edge 216 with respect to the radial plane 11 to confirm that peripheral surface 204 is covered by flange 26.

Please replace paragraph [0029] with the following paragraph:

[0029] In order to test the strength of the joint formed by bending the first plurality of arcuate projections 40, 40', ...40" into engagement with edge 206 of the second peripheral surface 204 on the second shell 30, the shell 10 and 30 were pulled apart. [##] It was determined that an angle of 14-20 degrees provided an initial holding force of between 3820 to 4350 pounds. In a situation where the second shell 30 was actually pulled away from the shoulder 20 with a force greater than 4350 pounds, the tabs 44, 46 engaged the second peripheral surface 216 to

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prevent bead 27 from separating from the groove 23 and a leak occur across the resulting joint.